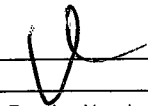
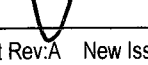


Date: Tuesday, 22/05/2007 2:57:48 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARPAW SKI INSTALLATION
Job Number : 32494	
Estimate Number : 12870	
P.O. Number : N/A	Part Number : D427659013
This Issue : 22/05/2007 S.O. No. : N/A	Drawing Number : IIN D4127-659 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 22/05/2007 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : 	Due Date : 23/05/2007 Qty: 1 Um: Each
Checked & Approved By : 	
Comment : Est Rev:A New Issue 07-05-22 JLM	

Additional Product

Job Number:



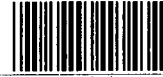
Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------

**Comment:** DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD427-659-013 CHG001

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

PULL FROM STK:

1 X D427-659-011 B 30576

ADD FOLLOWING TO KIT:

3.0	D427659011	See *K10008 Bearpaw Kit
-----	------------	-------------------------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

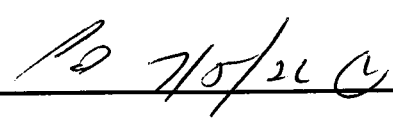
See *K10008 Bearpaw Kit

4.0	D2182	Heat Shrink
-----	-------	-------------

**Comment:** Qty.: 7.8750 f(s)/Unit Total : 7.8750 f(s)

Heat Shrink

18pcs X 5.00" LONG

Batch: B17095B18020

Date: Tuesday, 22/05/2007 2:57:48 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW SKI INSTALLATION

Job Number: 32494

Part Number: D427659013

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0	D2274	Radius Block
-----	-------	--------------



Comment: Qty.: 36.0000 Each(s)/Unit Total : 36.0000 Each(s)

Radius Block

Batch: B17929

6.0	D2438	Clamp
-----	-------	-------



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Clamp

Batch: B17512

7.0	D2529	Washer
-----	-------	--------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Batch: B17520

8.0	D30031	Bearpaw
-----	--------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bearpaw

Batch: 18119

9.0	D30041	SKI-CENTER SECTION
-----	--------	--------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SKI-CENTER SECTION

Batch: 18120

10.0	D3005041	Wearplate
------	----------	-----------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Wearplate

Batch: 14131

11.0	D3006041	Wearplate
------	----------	-----------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Wearplate

Batch: 14130

EC 7/5/22 (1)

Date: Tuesday, 22/05/2007 2:57:48 PM

User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW SKI INSTALLATION

Job Number: 32494

Part Number: D427659013

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN415A

Bolt



Comment: Qty.: 36.0000 Each(s)/Unit Total : 36.0000 Each(s)

Bolt

Batch: M10931

13.0

AN960JD416

Washer



Comment: Qty.: 36.0000 Each(s)/Unit Total : 36.0000 Each(s)

Washer

Batch: M11151

14.0

MS21042L4

Nut



Comment: Qty.: 36.0000 Each(s)/Unit Total : 36.0000 Each(s)

Nut

Batch: M10132

15.0

D2732

Rubber Extrusion



Comment: Qty.: 7.5000 f(s)/Unit Total : 7.5000 f(s)

Rubber Extrusion

18pcs x 5.0"

Batch: B26472

Per 10/22 (1)

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

207/05/23 (1)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D427-659-013
USING NEW B/N - NEW PAPERWORK AND LABELS REQ'D

Location:

PPP Rev:

Rev Draft

7/5/23

sq

Date: Tuesday, 22/05/2007 2:57:48 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW SKI INSTALLATION

Job Number: 32494

Part Number: D427659013

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

2007/05/23

Job Completion



2007/05/23

WK 36

DART AEROSPACE LTD		Work Order:	18159
Description: Ski Installation Kit		Part Number:	K10016
		Qty:	1

Step	Location	Procedure	By	Date	Qty																																																
1	DC	Open Traveller																																																			
2	DC	Photocopy bluefiles: K10016 and create labels per PPP K10016 WK 36	HA	02.09.06	1																																																
3	PK	Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>18</td> <td>D2182B050</td> <td>Rubber cushion</td> <td>B1820-B17095</td> </tr> <tr> <td>36</td> <td>D2274</td> <td>Radius block</td> <td>B17929</td> </tr> <tr> <td>18</td> <td>D2438</td> <td>Clamp</td> <td>B17512</td> </tr> <tr> <td>16</td> <td>D2529</td> <td>Washer</td> <td>B17520</td> </tr> <tr> <td>2</td> <td>D3003-1</td> <td>Ski fwd section</td> <td>B18119</td> </tr> <tr> <td>2</td> <td>D3004-1</td> <td>Ski center section</td> <td>B18120</td> </tr> <tr> <td>2</td> <td>D3005-041</td> <td>Wearplate</td> <td>B14131A</td> </tr> <tr> <td>2</td> <td>D3006-041</td> <td>Wearplate</td> <td>B14130A</td> </tr> <tr> <td>36</td> <td>AN4-15A</td> <td>Bolt</td> <td>M10931</td> </tr> <tr> <td>36</td> <td>AN960JD416</td> <td>Washer</td> <td>M11151</td> </tr> <tr> <td>36</td> <td>MS21042L4</td> <td>Nut</td> <td>M10132</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	18	D2182B050	Rubber cushion	B1820-B17095	36	D2274	Radius block	B17929	18	D2438	Clamp	B17512	16	D2529	Washer	B17520	2	D3003-1	Ski fwd section	B18119	2	D3004-1	Ski center section	B18120	2	D3005-041	Wearplate	B14131A	2	D3006-041	Wearplate	B14130A	36	AN4-15A	Bolt	M10931	36	AN960JD416	Washer	M11151	36	MS21042L4	Nut	M10132		02.09.03	1
Qty	Part Number	Description	Batch																																																		
18	D2182B050	Rubber cushion	B1820-B17095																																																		
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2	D3003-1	Ski fwd section	B18119																																																		
2	D3004-1	Ski center section	B18120																																																		
2	D3005-041	Wearplate	B14131A																																																		
2	D3006-041	Wearplate	B14130A																																																		
36	AN4-15A	Bolt	M10931																																																		
36	AN960JD416	Washer	M11151																																																		
36	MS21042L4	Nut	M10132																																																		
4	QC4	Inspect 100% Kit for completeness																																																			
5	KP	Identify and pack as per PPP K10016	AR	02.09.10	1																																																
6	AC	Cost part 669.87	Q	02-09-10	1																																																
7	DC	Close W/O	HA	02.09.11	1																																																
		Inspect Level 21	HA	02.09.11	-																																																

as per
attachment5772
9235

BB 800 02-09-11

Rev	Date	Change	Revised By	Approved
A	02.08.23	New issue	KJ	

RELEASED
02/08/27 RF

REFERENCE ONLY

Date: Tuesday, 22/05/2007 2:50:34 PM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 30576	Customer	: Dart Helicopters Services
Estimate Number	: 12618	DWG Name	: BEARPAW KIT (19"X24")
Purchase Order #	:	Part Number	: D427659011
Complete Date	: 12/03/2007 10:15:30	DWG Number	: D2432 REV F3
		Rev.	: F3

DUE DATE	ORDERED	DELIVERED
12/02/2007	4	4

2.0 MUHMWB10-UHMW 1" Black	INVENTORY ITEM
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DATE	EMPLOYEE	TYPE	Qty	COST	Lot # 103315 Qty. 27
05/03/2007	LAMA01: Lamarche, Mathieu	MUHMWB10	27.300	\$520.93	
Subtotal:	QTD:	0 CTD:	27	\$520.93	

3.0 HAAS1	Internal Operation
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DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
03/03/2007	LAMA01: Lamarche, Mathieu	Setup	0.000	0.70	\$12.32	0.70	55.30
03/03/2007	LAMA01: Lamarche, Mathieu	Run	0.000	3.62	\$63.71	3.62	285.98
06/03/2007	DROU01: Drouin, Simon	Run	4.000	9.05	\$159.28	9.05	714.95
Subtotal:	QTD:	4 CTD:	0	13.37	\$1291.54		

6.0 PACKAGING 1	Internal Operation
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DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach.Cost
08/03/2007	DESJ02: Desjardins, Line	Run	1.000	0.19	\$2.94	0.19	3.80
08/03/2007	FAUT01: Fauteux, Melanie	Run	4.000	1.21	\$23.33	1.21	24.20
Subtotal:	QTD:	5 CTD:	0	1.40	\$54.27		

7.0 D2182B-Neoprene Cushion-.750 bi	INVENTORY ITEM
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DATE	EMPLOYEE	TYPE	Qty	COST	Lot # 30397 Qty. 10
08/03/2007	FAUT01: Fauteux, Melanie	D2182B	10.000	\$4.59	
Subtotal:	QTD:	0 CTD:	10	\$4.59	

8.0 D2274-Radius Block	INVENTORY ITEM
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DATE	EMPLOYEE	TYPE	Qty	COST	Lot # 30518 Qty. 48
08/03/2007	FAUT01: Fauteux, Melanie	D2274	48.000	\$104.44	
Subtotal:	QTD:	0 CTD:	48	\$104.44	

9.0 D2438-Clamp	INVENTORY ITEM
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DATE	EMPLOYEE	TYPE	Qty	COST	Lot # 30381 Qty. 24
08/03/2007	FAUT01: Fauteux, Melanie	D2438	24.000	\$15.38	
Subtotal:	QTD:	0 CTD:	24	\$15.38	

10.0 D2529-Washer	INVENTORY ITEM
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DATE	EMPLOYEE	TYPE	Qty	COST	Lot # 30382 Qty. 48
08/03/2007	FAUT01: Fauteux, Melanie	D2529	48.000	\$1.96	
Subtotal:	QTD:	0 CTD:	48	\$1.96	

11.0 AN415A-Bolt	INVENTORY ITEM
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DATE	EMPLOYEE	TYPE	Qty	COST	Lot # 103585 Qty. 48
08/03/2007	FAUT01: Fauteux, Melanie	AN415A	48.000	\$11.25	
Subtotal:	QTD:	0 CTD:	48	\$11.25	

REFERENCE ONLY

Date: Tuesday, 22/05/2007 2:50:34 PM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 30576	Customer	: Dart Helicopters Services
Estimate Number	: 12618	DWG Name	: BEARPAW KIT (19"X24")
Purchase Order #	:	Part Number	: D427659011
Complete Date	: 12/03/2007 10:15:30	DWG Number	: D2432 REV F3
		Rev.	: F3

12.0 AN960JD416-Washer INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
08/03/2007	FAUT01: Fauteux, Melanie	AN960JD416	48.000		\$1.68	Lot # 103338 Qty. 48	
Subtotal:		QTD:	0	CTD:	48	\$1.68	

13.0 MS21042L4-Nut INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
08/03/2007	FAUT01: Fauteux, Melanie	MS21042L4	48.000		\$5.42	Lot # 103349 Qty. 48	
Subtotal:		QTD:	0	CTD:	48	\$5.42	

14.0 D2732-Rubber Extrusion INVENTORY ITEM							
DATE	EMPLOYEE	TYPE	Qty		COST		
08/03/2007	DESJ02: Desjardins, Line	D2732	10.000		\$37.35	Lot # 26472 Qty. 10	
Subtotal:		QTD:	0	CTD:	10	\$37.35	

16.0 PACKAGING-1 Internal Operation							
DATE	EMPLOYEE	TYPE	Qty	Time(hrs)	COST	MTime(hrs)	Mach. Cost
09/03/2007	DESJ02: Desjardins, Line	Run	4.000	0.64	\$9.89	0.64	12.80
09/03/2007	BOUC02: Boucher, Emilie	Run	4.000	0.69	\$10.66	0.69	13.80
Subtotal:		QTD:	8	CTD:	0	1.33	\$47.15

		TIME	COST
	Machine Time:	16.10	\$1110.83
	Labor:	16.10	\$282.13
	Sub-contract (external Op.):		\$0.00
	INVENTORY ITEM:		\$703.00
	SUB-COMPONENT (SUB-JOB):		\$0.00
Total:			\$2095.96

COST PER UNIT:		\$523.99
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